

Date: Wednesday, 11/06/2006 10:04:32 AM
 User: Eric Charbonneau

Process Sheet

Customer : CC-DAR01 Drawing Name : SKIDTUBE EC135 PROTOTYPE
 Job Number : 022A
 Estimate Number : 10068 Part Number : INITIAL PROTOTYPE **D3510-041**
 P.O. Number : **N/A** Drawing Number : P601-637
 This Issue : 7/19/2006 S.O. No. : **N/A** Project Number : P601-637
 Prsht Rev. : NC Drawing Revision : **N/A**
 First Issue : 5/9/2006 Type : R & D LANDING GEAR Material : **N/A**
 Previous Run : 020A Due Date : 2/1/2006 Qty: 1 Um: Each
 Written By : _____
 Checked & Approved By : _____
 Comment : Project #: _____
 Description: _____

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MFG ENGINEERING MFG ENGINEERING



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

MFG ENGINEERING

Manufacture Prototype as per Dwg's Supplied By Engineering

Comments:

Turn as per Dwg **D3510**
 Mat'l **M6061T6T3500W0375** Batch: **1011113** Qty: **3**
 Inspect Level 2 **BC 06.07.27**
 Mill - Mill as per Dwg **Jul 06.08.11**
 QC2 - Inspect **Jul 06.08.11**
 QC8 - Second Check **06.08.28** (NOT A JOINT)
 Welding - Weld as per ENJ - Fill Hole for repair
 A/R AL. ROD Batch: **M100660** BE **06-08-15**
 GA - Transfer Drill Wear Plate Holes **Jul 06.08.16**
 Fin. - Chemical Conversion as per Part ASI 005 4.1 **06.08.18**
 QC3 - Inspect ECC. **06.08.24**
 PTH **06.08.18**
 PTO

2.0 PG PURCHASING



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

PURCHASING

Attached certificate of conformity for raw material and subcomponents use for this w/o

Pick:

Qty	Part #	Desc	Batch
2	NAS1330C4KB271	INSERT	M101325
6	NAS133C3KB316	INSERT	M17905
2	NAS1330C3KB216	INSERT	M17905

06.06.18

Finishing Install INSERTS AS PER DWG D3510

QC5 Inspect Work To Current Step

06.06.18

ST Identify Stock

Place into
em's lab
06.06.18

Process Sheet

Drawing Name: SKIDTUBE EC135 PROTOTYPE

Part Number: INITIAL PROTOTYPE

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes with the objectives and goals to determine the effectiveness of the project and identify areas for improvement.

Seq. #:	Machine Or Operation:	Description :
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96	1000	1000
97	1000	1000
98	1000	1000
99	1000	1000
100	1000	1000

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PACKAGING RESOURCE #1
Identify "FOR ENGINEERING USE ONLY" and distribute to engineering.

06-06-15

4.0 ENGINEERING 1 ENGINEERING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
ENGINEERING RESOURCE #1
Approval of project manager_____

5.0 DC DOCUMENT CONTROL



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
DOCUMENT CONTROL
Inspection Level 21

Mar. 08. 25

6.0	MFG ENGINEERING	MFG ENGINEERING
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
MFG ENGINEERING
Manufacture Prototype as per Dwg's Supplied By Engineering
Comments:

U/A ~~ed~~
 eering 06-08-15

W. 2008.16

Technical drawing of a mechanical part showing four cross-sections and a detail view.

SECTION J-J (SCALE 1:3)

- Overall width: 0.50
- Inner diameter: $\phi 2.940$
- Outer diameter: $\phi 3.300$
- Section thickness: 2.96

SECTION A-A (SCALE 1:3)

- Overall width: 0.50
- Inner diameter: $\phi 2.750$
- Outer diameter: $\phi 3.300$
- Section thickness: 2.96

SECTION B-B (SCALE 1:3)

- Overall width: 0.520
- Inner diameter: $\phi 2.750$
- Outer diameter: $\phi 3.300$
- Section thickness: 3.15
- Radius: R0.031 (TYP)

SECTION C-C (SCALE 1:3)

- Inner diameter: $\phi 2.750$
- Outer diameter: $\phi 3.265^{+0.000}_{-0.010}$

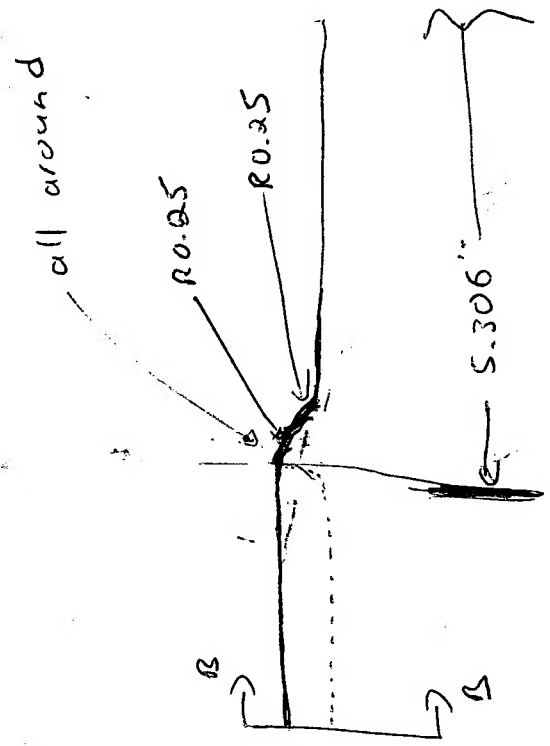
DETAIL G (SCALE 1:3)

- Radius: R0.25
- Dimension: 0.066
- Feature: FLIP OVER

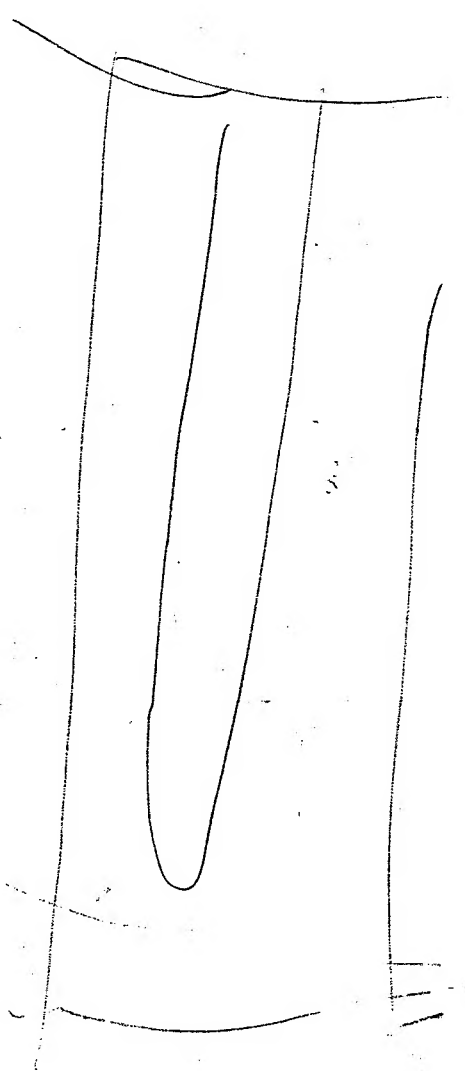
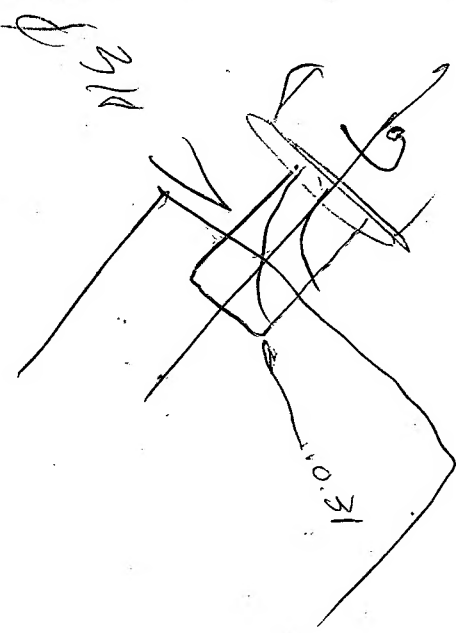
VIEW F (SCALE 1:3)

- Radius: R0.19
- Radius: R0.125
- Radius: R0.12
- Dimension: 5.270
- Dimension: $\phi 0.0705$

0.063 X 45° CHAMFER



DETAIL C



2

556.25

258.2

1000.00

13.520

212.9



DART AEROSPACE LTD		Work Order:
Description: <i>Strut brace insert</i>		Part Number: <i>D3510-1</i>
Inspection Dwg: <i>D3510</i> , Rev: <i>A</i>		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST *Page 1 of 2*

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.50	±.03					
2.300	±.010					
2.940	"	2.940	✓			
2.96	±.03					
.50	"					
.520	±.010					
3.265	±.010	3.263	✓			
3.265	±.010					
3.19	±.03					
.12	"					
3.25	"	3.25	✓			
.066	±.010	.066	✓			
.063 x 45°	±.010	.063	✓			
30.50	±.03	30.50	✓			
15.00	"	15.00	✓			
12.25	"					
12.25	±.010		✓			
12.5 x 45°	"	12.5	✓			
5.270	"	5.270	✓			
6.735	"					
25.277	"	25.277	✓			
2.981	"					
2.474	"					

Measured by: <i>BG1</i>	Audited by: <i>[Signature]</i>	Prototype Approval: <i>[Signature]</i>
Date: <i>06.08.27</i>	Date: <i>06.08.26</i>	Date: <i>06.08.26</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

05/02/2006 From: MARMON/KEYSTONE
M/K OR:
C.P.O. BN9722
C PART:

To:

INIT.

OR. REF:
SLSPRS:

M101448

KAISER ALUMINUM
ENGINEERED PRODUCTS
9700 SOUTH HARLEM AVE
BRIDGEVIEW IL 60455

KAISER ALUMINUM
MATERIAL CERTIFICATION
MARMON-KEYSTONE CORP
10700 MARMON DR
BOLINGBROOK, IL 60440-3060

PAGE 1

MARMON-KEYSTONE CORP

BOLINGBROOK

IL 60440 60-23640

04/12/06

SOLD TO

PURCHASE ORDER

DATE PRINTED

3.500 +/- .015 IND +/- .015 MEAN O.D.

HB3.500X0.375X24FT

X .375 WALL SMLS HOLOBAR

CUSTOMER PART NUMBER

DESCRIPTION

983171-003

101148094

6061-T6511

RELEASE-ITEM

LOT

ALLOY/TEMPER

MECHANICAL PROPERTY RESULTS

REFERENCE	SAMPLE#	UTS(KSI)	YTS(KSI)	%Elong in 2"	HARDNESS	CONDUCT.	BEND
KTR044478	0001 01	47.6	42.5	18.4		N/A	N/A

CHEMICAL COMPOSITION (WT%), ALUMINUM REMAINDER

6061 LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Others
Maximum	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	NA	NA	NA	Ea Tot
Minimum	0.40		0.15		0.8	0.04			NA	NA	NA	0.05 0.15

APPLICABLE REQUIREMENTS:

ASTM-B241-02-STENCILED
ASTM-B221-02
ASME-SB241 1998 SECT II
AMS-QQ-A-200/8 TYPE 1
ASTM-B345-02
UNS#96061

Kaiser Aluminum & Chemical Corp. ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgment form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file, subject to examination.

Q. C. REVIEWED

Frank B. Watson
Quality Assurance Manager

AT 3.5.375 733